Work Orde Wednesday, Octo											Page 1
Revision ID:	D3535-23 Wearshoe			Accept				s	etup Star		
Start Date: Required Date: Reference:	10/6/2010 10/15/2010	Start Qty: 12.00 Req'd Qty: 12.00	1 1818 1818 1811 1811 1 1888 1818 1811 1814		Cust Item I Customer:	D:				· Jamesa,	
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):		ate:	- 	R	dun Sta Sto		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr	÷								
D3535	Rev 1	В									
Waterjet FLOW CNC Waterjet 344.040	ot	FLOW WATER JET Memo 1-Cut as pe Deburr if n	or Dwg D3535 □Dwg Rev: ecessary	0.00 0.00 ■ □Prog Rev: _	3□2-			(<u>R</u>	10-10	-1 8 (13)
110 QC Quality Control		QC2- Inspect parts off a Memo	nachine FAI/FAIB	0.00				1210)- <u> </u> \\	8	

Quality Control

QC8- Inspect parts - second check

0.00

Memo

JM-03 A1272

0.00

W/O:			WC	RK ORDER CHANG	GES		 		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			otion B	Approval	Approval		
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Work Order ID 62706

Page 2

Item ID:

D3535-23

Wednesday, October 06, 2010 3:21:07 PM

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Wearshoe

10/6/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

0.00

Set Up/

Run Hours

Date:

Date:

Start Run

Stop



Required Date: 10/15/2010

OC:

Date: SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Work Center ID

130

Sequence ID/

Brake NC Brake NC

Memo

Operation

Description

NC BRAKE

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form joggle as per Dwg D3535 using Jig DT8158□3-Identify as D3535-23

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150

Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00 EX 10-10-22

Powder Coating

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 62706

Wednesday, October 06, 2010 3:21:07 PM



Page 3

Item ID:

D3535-23

Accept



Setup Start



Stop

Revision ID:

Start Date:

Item Name:

Required Date: 10/15/2010

Wearshoe

10/6/2010

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Reject Qty

Reject Number

Insp. Stamp

Work Center ID 160

Sequence ID/

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

10/10/27

Qty

X13 9

170

Packaging Packaging

Memo

Identify as per dwg & Stock Location: FP31 0.00 BL 10-10-22

0.00

180

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/2298) MF 10-10-22

W/O:			W	ORK ORDER CHAN	IGES					
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Picklist Print

Wednesday, October 06, 2010 3:21:11 PM

Work Order ID: 62706

Parent Item: D3535-23

Parent Item Name: Wearshoe



Start Date: 10/6/2010

Required Date: 10/15/2010

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

MAT20

112885

113062 115440

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	108.6987	1.3615	17.19789	18. 180-10-	_	
				Location		Loc (<u>Qty</u>	Loc Code					
					114574 115762	10.6	9522 6522 75.3			15762	E	3	

22.7465 2.7475

0.699

19.3

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DART AEROSPACE LTD	Work Order:	42706
Description: Wearshoe	Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

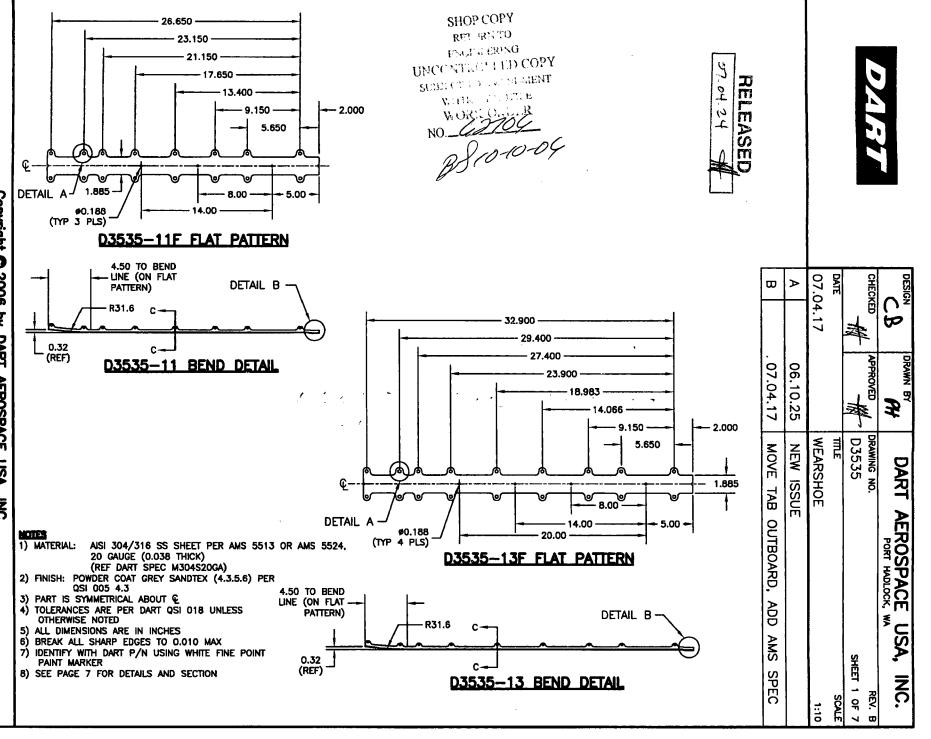
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Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
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2.000	+/-0.010	0000 G	8		v	
4.750	+/-0.010	4,750	100		V	
9.500	+/-0.010	9,500	छ		7 BO1	
14.250	+/-0.010	14.250	4		T	
17.750	+/-0.010	17.750	8		7	
23.140	+/-0.010	23.140	Ø		τ	
28.530	+/-0.010	38.530	یم		7	
33.920	+/-0.010	33,900	ð	_	7	
39.310	+/-0.010	39.310	8		7	
44.700	+/-0.010	44.700	7		7	
48.200	+/-0.010	48.000	7		7	
52.850	+/-0.010	Ox8.62	2		7	
Ø0.188	+0.005/-0.001	,193	80		V	
48.00	+/-0.030	48.00	K		7	
39.00	+/-0.030	39.00	×		7	
32.00	+/-0.030	33.00	≫		T	
24.00	+/-0.030	24,00	×		7	
16.00	+/-0.030	16,00	7		7	
8.00	+/-0.030	8.000	>		V	
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0.300	+/-0.010	.306	>		V	
0.038	+/-0.010	,036	* 1		V	

Measured by:	ıR.	Audited by:		Prototype Approval:	N/A
Date:	10-10-19	Date:	/INIOP	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.11.23	New Issue	KJ/EC/DD	<i>M</i>
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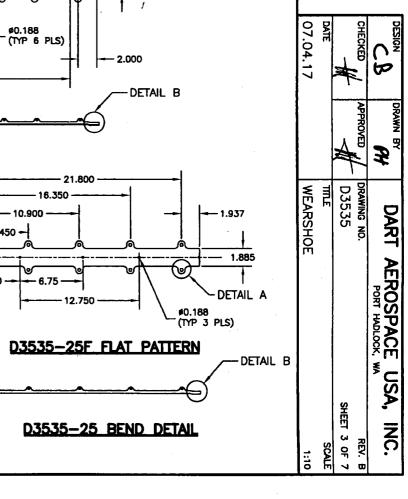
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W/O:			WC	RK ORDER CHANG	ES	····				
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PURPOSE

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NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

52.850

39.310 -

33.920

28.530

23.140

16.00

C--

- 24.00

32.00

39.00

48.00

1.450 ·

R0.063 (TYP)

(TYP)

R0.25 TOOLING NOTCH

D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL

---- 17.750 14.250 ----

8.00

9.500

4.750

- 6.00

20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

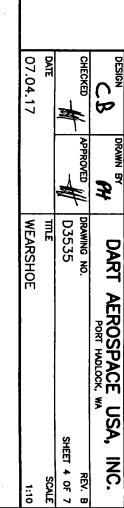
B) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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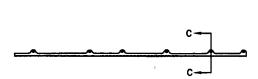






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D3535-31 BEND DETAIL

D3535-31F FLAT PATTERN

22.500 19,000

> DETAIL A #0.188 (TYP 3 PLS)

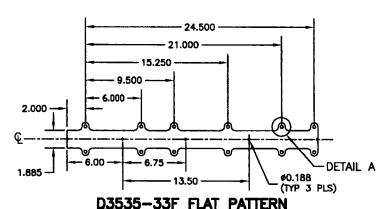
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PURPOSE

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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

- 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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DATE

07.04.17

WEARSHOE

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D3535-35F FLAT PATTERN

#0.188

(TYP 2 PLS)

DETAIL A

23.250 19.750

17.750

9.500

4.750

2.000

1.885



30.750
27.250
22.500
17.750
14.250
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1.885 6.00 8.00 DETAIL A
D3535-37F FLAT PATTERN (TYP 4 PLS)

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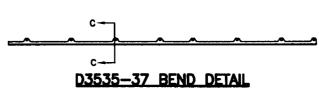
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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

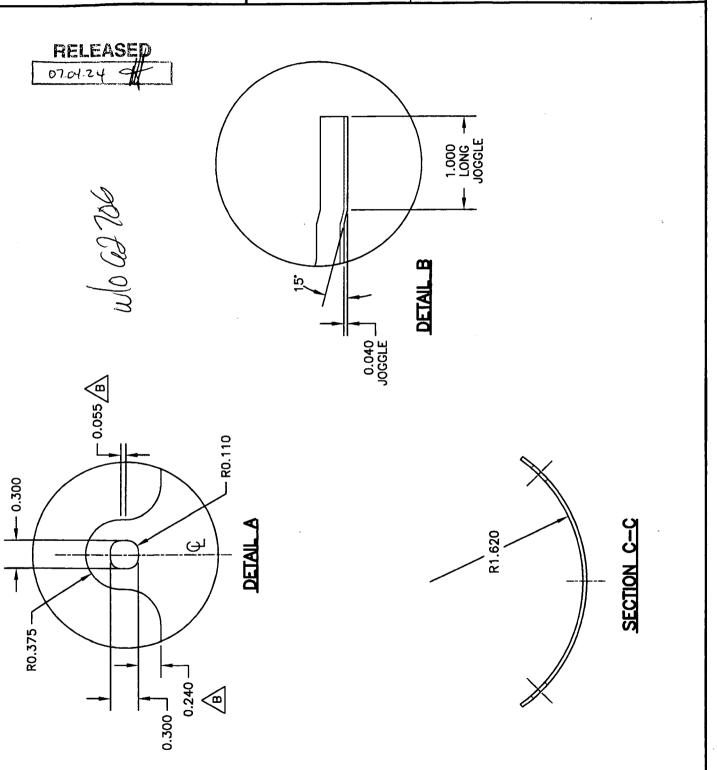


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07.04.17		WEARSHOE	1:1



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DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
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